

## Patent claims

1. Method for producing a conductive contact part (10) for a detachable electrical plug-in connection, where a contact element (20) with a sectionally lengthwise slotted bushing part (23),  
5     featuring ribs (26) arranged distributed around its circumference is provided, and a sleeve part (30) surrounding the bushing part (23) and covering its ribs (26) is provided with two opposing end faces (31, 32),  
characterized in that,  
10     the sleeve part (30) is arranged and positioned almost coaxially to the bushing part (23) so as to cover its ribs (26), that the positioned sleeve part (30) is locked by one of its two ends (31, 32) on the bushing part (23), that the bushing part (23) is twisted elastically around the central axis (13) such that the ribs (26)  
15     bend in the shape of arcs towards the central axis (13), and that the sleeve part (30) is locked with the other of the two ends (32, 31) to the bushing part (23) held twisted against the elastic recovery force of the ribs (26).
2. Method according to Claim 1,  
20     characterized in that,  
the sleeve part (30) is locked onto to the bushing part (23) by mechanical locking.
3. Method according to Claim 1,  
characterized in that,  
25     the sleeve part (30) is locked onto to the bushing part (23) by laser welding.
4. Method in accordance with one of the Claims 1 to 3,  
characterized in that,  
a radial expansion protection ring (37) extending around the  
30     circumference is pressed into the positioned sleeve part (30).

5. Method in accordance with one of the Claims 1 to 4,  
characterized in that,  
at least one radially extended section (24, 25) is formed on the  
contact element (20).

5 6. Method in accordance with one of the Claims 1 to 5,  
characterized in that,  
that flat contact arrangements of the contact element (20), and if  
necessary of the sleeve part (30) repeating at a particular spacing  
distance are punched out of a strip material, with the arrangements  
10 remain connected to a carrier tape (40) of the strip material, that  
the punched-out contact arrangements are surface-treated, and that  
the contact element (20) is formed from the contact arrangements by  
rolling the bushing part (23) and bending up connection tabs (21,  
22) and if necessary the sleeve part (30), is formed through  
15 rolling.

7. Method according to Claim 6,  
characterized in that,  
locating tabs (33) and locating cutouts (34) arranged in pairs are  
formed on the contact arrangement of the sleeve part (30), in which  
20 case, when the sleeve part (30) is rolled, the locating tabs (33)  
engage in the assigned locating cutouts (34) to form a tight fit.